

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004781**Date Inspected:** 11-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Changxing Island, Shanghai

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes	No N/A
		Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006	Component:	OBG and tower components	

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

Part # Lift 1 Skin C.

1. The QA Inspector performed a random Visual (VT) and Ultrasonic Testing (UT) verifications on the Complete Joint Penetration (CJP) butt splice welds identify as weld number: NSD1- SA179D/E- 26A/B, NSD1- SA179D/E-27A/B, NSD1- SA179D/E- 29A/B, NSD1- SA179E/E- 1A/B, NSD1- SA179E/E- 4A/B, NSD1- SA179D/E- 31A/B, NSD1- SA179D/E- 28A/B, NSD1- SA179D/E- 30A/B, NSD1- SA179E/E- 3A/B and NSD1- SA179E/E- 2A/B on inspection part LIFT 1 SKIN C for the tower section. Please see the ZPMC Non Destructive Examination (NDE) notification document number 001391 for additional information. The QA Inspector performed the UT verification after ZPMC QC Inspectors reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any rejectable welding discontinuities on any of the verified welds mentioned above. The QA Inspector notified ZPMC QC Inspection personnel and Task Leader Albert Carreon of the QA Inspector verification results. Please see the QA Inspector Ultrasonic Test report (TL 6027) generated on this date for additional information.

Part # NSD1-SA11

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2. The QA Inspector was requested to perform UT verification on a weld repaired area made on a complete joint penetration weld joint number NSD1SA11E/F on inspection part NSD1-SA11 for the tower section. At the time of arrival at the heavy shop number 1 the QA Inspector could not locate the inspection part and requested ZPMC QC Inspection personnel to provide support to find this weld. ZPMC QC Inspection personnel notified the QA Inspector the weld could not be found due to the weld identification number on item number 2 of the ZPMC notification of witness inspection document number 001389 was not correct.

Summary of Conversations:

As noted in the body of the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
